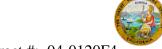
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-002564 Address: 333 Burma Road **Date Inspected:** 23-May-2008

City: Oakland, CA 94607

OSM Arrival Time: 630 **Project Name:** SAS Superstructure **OSM Departure Time:** 1530 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island

CWI Name: See below **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Skin plates

Summary of Items Observed:

The name of ABF Certified Welding Inspector (CWI) are Mr. Wang Cheng Jun, Mr. Yang Yi Heng, Mr. Kong Xian Hui and Mr. Dai Zing Wen.

Heat straightening on skin plate (Tower Bay#1) Caltrans Quality Assurance Inspector (QAI) observed few Zhenhua Port Machinery Co (ZPMC) heat straightening operators performed heat straightening with ZPMC Heat Straightening Report (HSR) on plate numbered P263, P291B, P150, P968 and P389B. The heating temperature is maximum 650 C (1200 F) and cool in still air. All the plates have been monitored and recorded and inspected by ZPMC QC required within from 0.5mm to 1mm off set (Caltrans requirement Max 3mm) after heat straightening to cooled to ambient temperature. Based on Caltrans QAI observation, no discrepancies were noted.

Flux Cored Arc Welding (FCAW) welding process on skin plate (Tower Bay#1): Caltrans QAI observed two welders were performing FCAW process on splice weld of longitudinal stiffener for numbered P326 to P328 with 65mm wall thickness, weld# SSD1-SA159G/J-23A and longitudinal stiffener numbered P328 to P1028 with 65mm wall thickness, weld# SSD1-SA159G/J-24A. The parameters used for FCAW process of splice welds were conducted in accordance with Caltrans approved WPS-B-T-2231-B-U3-F. The electrode being used is super cored 71.H with 0.14mm diameter made by China Company. The FCAW process was monitored and recorded by ZPMC QC Inspector and ABF CWI. Base on Caltrans observation, no discrepancies were noted.

Magnetic particle testing (MT) on splice welds (Tower bay#2): Two ZPMC MT technicians performed QC 25% MT testing on two splice weld of skin plates. The test splice weld numbered # ESDA-SA77A/E-37A and ESD1-SA77A/E-35A. The grease, rust, scale and other moisture have been removed by ZPMC workers on both side 200mm of splice weld areas prior MT testing. The power source of MT testing is used electromagnetic yoke with Alternating Current (AC) made by Magnaflux. The detection media is used dry red ferromagnetic particles.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The technique uses dry particles that are applied while the magnetizing force is on. A field indicator used to check the magnetic filed direction and to ensure adequate field strength during MT testing. The 25% MT testing of three splice weld areas appeared to be in compliance with the requirements of AWS D1.5 (2002) and Caltrans contract documents.

Submerged Arc Welding (SAW) process on skin plate (Tower Bay#2): Caltrans QAI observed six ZPMC welding operators performed semi-automatic SAW on the splice weld of ASTM 709 345 skin plate numbered P1405 to P1401 with 45mm and 60mm wall thickness, weld# ESD1-SA294A/G-4B. The weld designed is a double -V-groove with welding conducted in the in flat position (1G) with proper 4.8mm diameter wire feed electrode JW3 and flux/J1-B, made by China Company and completed with approximate five pass. The parameters used for SAW welding of splice weld was conducted in accordance with Caltrans approved WPS-B-T-2221-B-U3. The semi-automatic SAW was monitored and recorded by ABF Certified Welding Inspector (CWI). Based on Caltrans QAI observations, no discrepancies were noted.

Summary of Conversations:

As Note within the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Wahbeh Mazen (818)292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer